

# Work Order ID 74147

Monday, September 26, 2011 9:48:03 AM



Page 1

Item ID: D4406-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Wearplate Assembly

Start Date: 9/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: W

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4406

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per dwg D4406

prog rev: A

dwg rev: A

2-Deburr if required

B11-9-27

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-9-27

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Page 2

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Customer:

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Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00

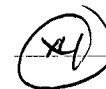


QC

Memo

0.00

Quality Control

Sulorber  
to Rev A

130

0.00



Small Fab

Memo

0.00

Small Fab

Form as per dwg D4406

SB 9/29/29



140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulorber



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Start Date: 9/26/2011 Start Qty: 4.00



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Required Date: 10/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

0.00



Large Fab

Memo

0.00

Large Fab

weld wearplate as per dwg D4406

(4)

MAL/12

11/11/25

160

0.00



QC

Memo

0.00

Quality Control

QC10- Inspect visual per QSI004- ground welds

CP 11-11-28

4

Ø

170

0.00



Small Fab

Memo

0.00

Small Fab

Apply coating as per dwg D4406

FC

11-11-29

(x4)

**Work Order ID 74147**

Page 4

Monday, September 26, 2011 9:48:03 AM

Item ID: D4406-041

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Stop



Item Name: Fwd Wearplate Assembly

Start Date: 9/26/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 10/7/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11 11 29 (4)

190

Identify as per dwg & Stock Location: F12-1

0.00



Packaging

Memo

0.00

Packaging

x8 11/11/29  
counted measure

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/30

ME 11-11-29

# Picklist Print

Page 1

Monday, September 26, 2011 9:48:01 AM

Work Order ID: 74147

Parent Item: D4406-041

Parent Item Name: Fwd Wearplate Assembly





Start Date: 9/26/2011

Required Date: 10/7/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev A 11.06.06 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4407-1 		Manufactured	No			150	Each	0.0000	1	4			
Bar M304S18GA 		Purchased	No			100	sf	55.5550	3.7	15.57895			
304/316 .050 Sheet													

B74151 X4

EL 11-11-24

AB11-9-27

## Location

## Loc Qty

## Loc Code

MAT020

55.555

113062

0.155

116979

55.4

119032

119032

(4)

DART AEROSPACE LTD		Work Order: 74147
Description: FWD WING PLATE ASSEMBLY		Part Number: D4406-041
Inspection Dwg: D4406-1 Rev: A		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

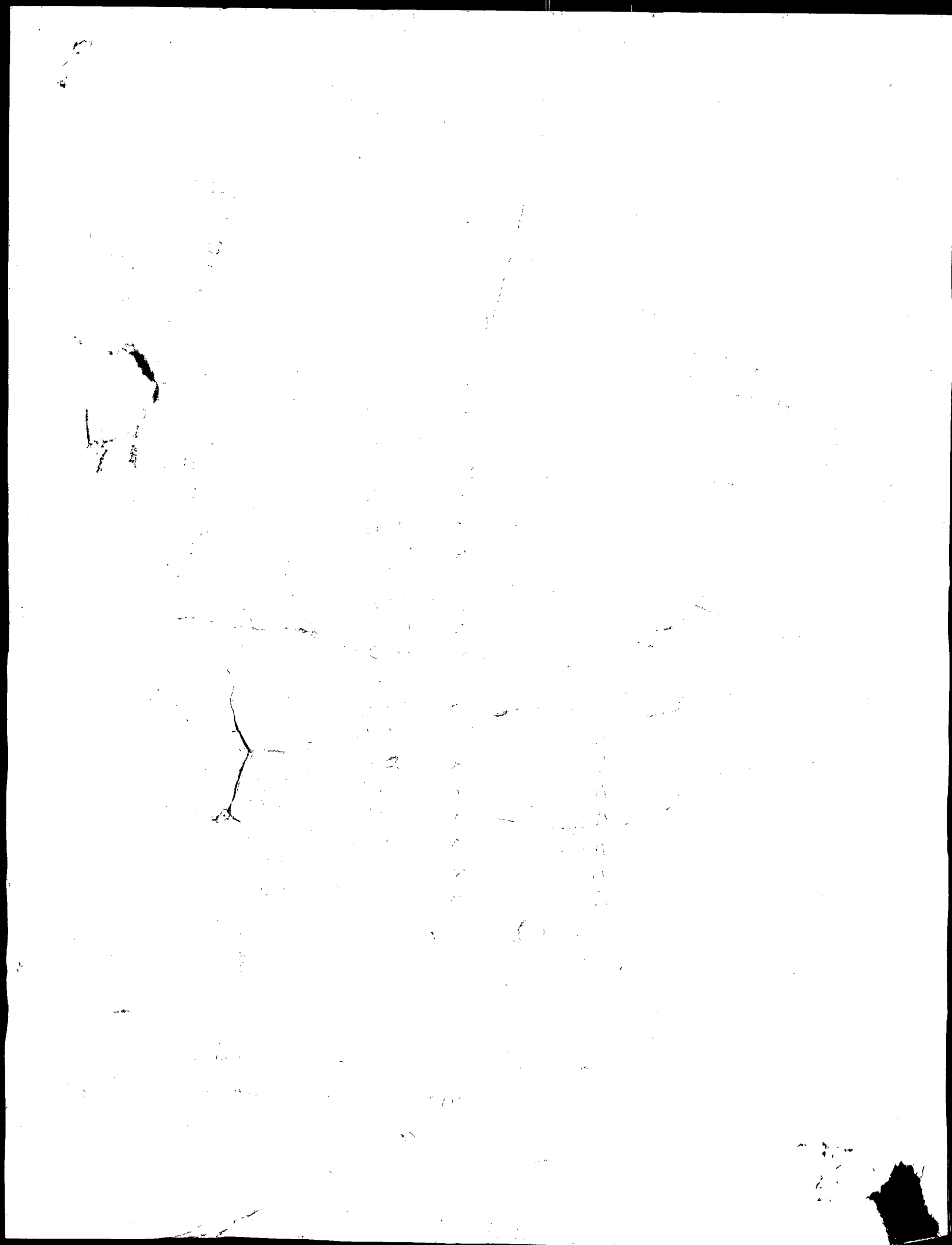
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
561	±.010	561	✓		V PB02	
.30	±.030	.308	✓		V	
.88	±.030	.88	✓		V	
.13	±.030	.125	✓		V	
.131	±.030	.1307	✓		V	
1.77	±.030	1.777	✓		V	
7.203	±.010	7.203	✓		V	
7.80	±.030	7.803	✓		V	
3.63	±.030	3.618	✓		V	
7.00	±.030	6.998	✓		V	
4.00	±.030	3.997	✓		V	
36.00	±.030	36.00	✓		T PB01	
66.06	±.030	66.06	✓		T	
2.43	±.030	2.444	✓		V	
7.167	±.010	7.157	✓		V	
7.77	±.030	7.768	✓		V	
12.745	±.010	12.745	✓		T	
37.308	±.010	37.308	✓		T	
63.734	±.010	63.734	✓		T	
1.050	±.010	1.048	✓		V	

Measured by: RB
Date: 11-9-07

Audited by: J
Date: 11/09/07

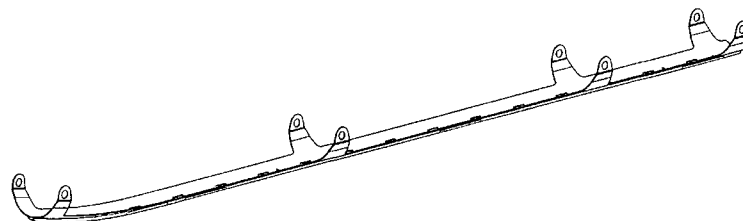
Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

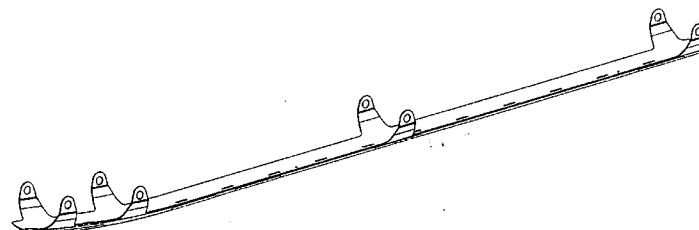


8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D4406-041	FWD WEARPLATE ASSY
2		X	D4406-043	AFT WEARPLATE ASSY
3	1		D4406-1	PLATE
4		1	D4406-3	PLATE
5	1		D4407-1	BAR
6		1	D4407-3	BAR
7	A/R	A/R	2059B	HARDCOAT
8	A/R	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 11, SHT 2 & 3)



**D4406-041 FWD WEARPLATE ASSY**



**D4406-043 AFT WEARPLATE ASSY**

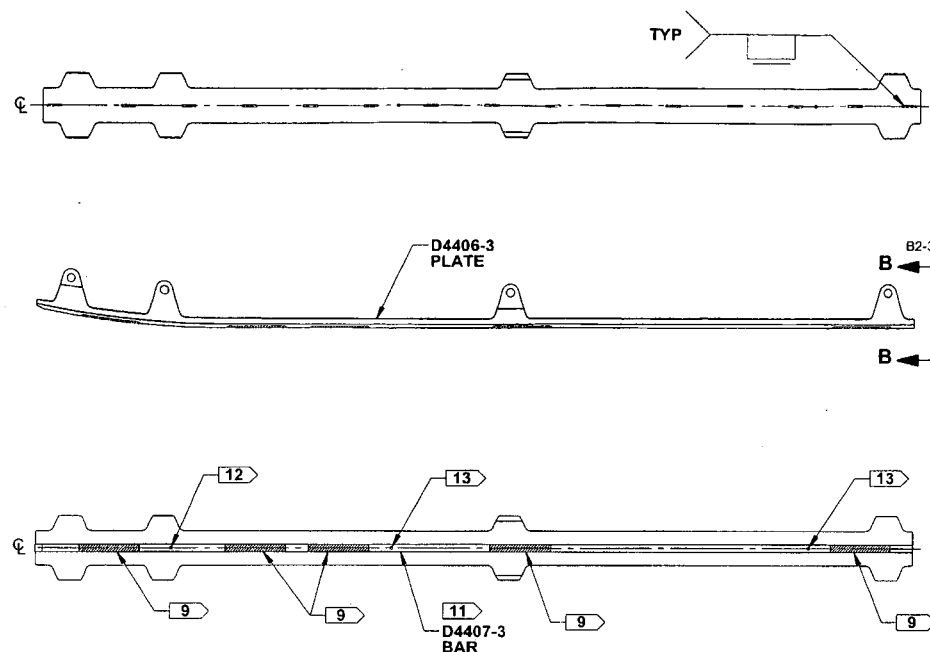
*W070147*

**RELEASED**  
R 2011-08-29

A		NEW ISSUE		RF	11.08.15
REV.	DESCRIPTION			BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		REV. A SHEET 1 OF 6	
DRAWN	RF				
CHECKED	<i>[Signature]</i>	DRAWING NO.		D4406	
MFG. APPR.	<i>[Signature]</i>	TITLE		WEARPLATE ASSY	
APPROVED	<i>[Signature]</i>	SCALE		NTS	
DE APPR.	<i>[Signature]</i>	DATE		11.08.15	
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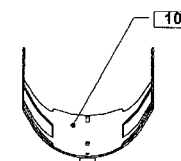
8 7 6 5 4 3 2 1







# **D4406-043 AFT WEARPLATE ASSY**

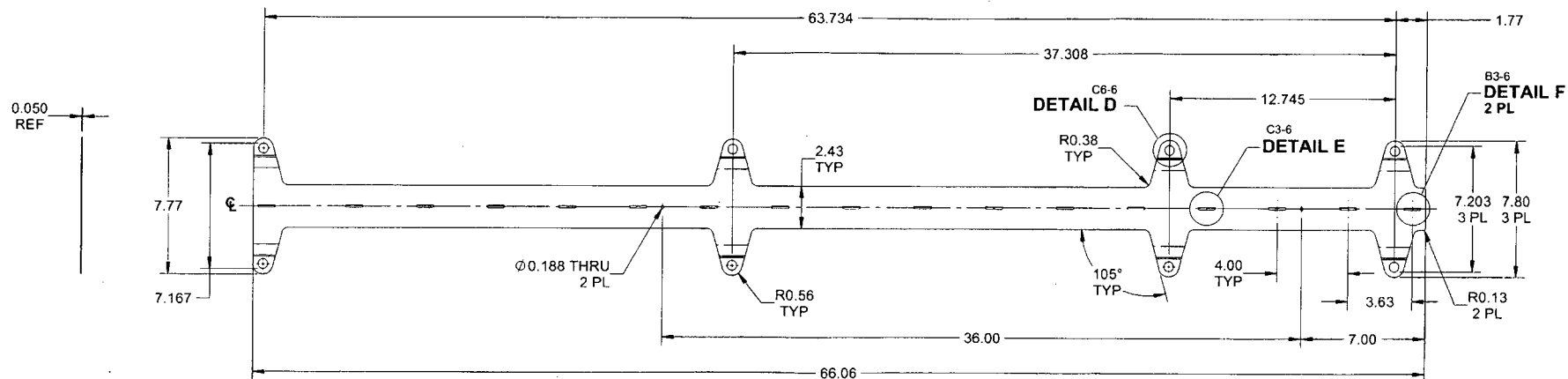
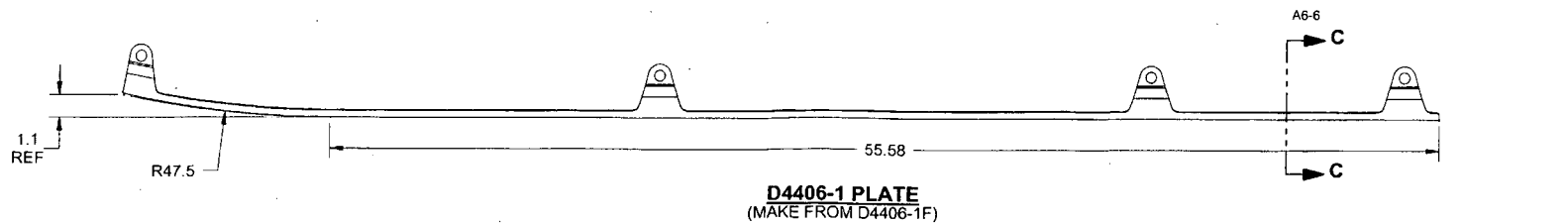
C3-3 **SECTION B-B**  
SCALE 2X



## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 4.57 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D4407-3 BAR ON ALL 3 SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING
- 12) FILL TOOLING HOLE WITH WELD ONE PLACE ONLY
- 13) TRANSFER  $\phi 0.188$  HOLES FROM D4406-3 TO D4407-3

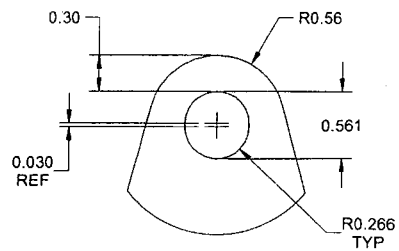
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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4406	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		<b>WEARPLATE ASSY</b>	NTS
DATE	11.08.15	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



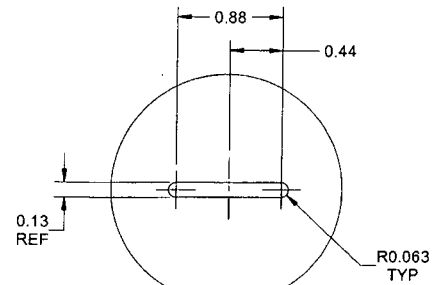
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)  
PER AMS 5513 OR 5524  
OR ASTM A240 OR ASME SA240  
REF. DART SPEC. M304S18GA
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 2.33 lbs

**RELEASED**  
2011-08-28  
JW

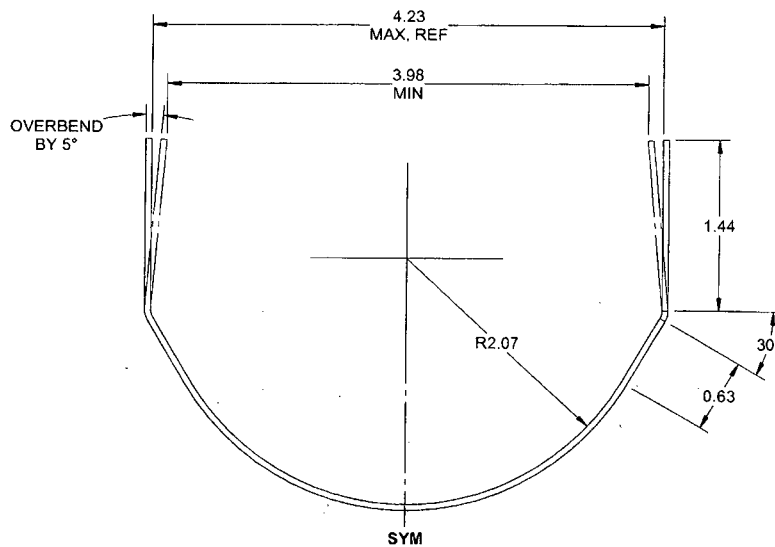
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MFG. APPR.	<i>DS</i>	TITLE <b>WEARPLATE ASSY</b>	SCALE NTS
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DE APPR.	<i>SA</i>		
DATE	11.08.15		



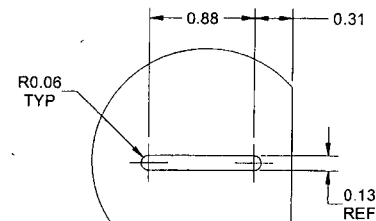
**DETAIL D**  
SLOT DETAIL TYP  
SCALE 6X



**DETAIL E**  
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SCALE 6X



**DETAIL C**  
DETAIL TYP  
SCALE 6X



**DETAIL F**  
SLOT DETAIL TYP  
SCALE 6X

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2011-08-29

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4406	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
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